


Date: Monday, 11/6/2006 1:37:24 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP LH
Job Number	: 29302		
Estimate Number	: 10855		
P.O. Number	: <i>N/A</i>	Part Number	: D206628021
This Issue	: 11/6/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 29119	Drawing Revision	: N/A
		Material	: <i>N/A</i>
Written By	: 	Due Date	: 11/27/2006
Checked & Approved By	: _____	Qty:	4 Um: Each
Comment	: Est Rev:D as per ECN 766 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-021 CHG 002

*KS 06.11.08* (4)

2.0	29302A	206L /407 STEP ASSY, LH
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Comment: Sub-Component SUB-COMPONENT  
 D2724-041 B \_\_\_\_\_

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug *B28074* ✓

5.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.1708 f(s)/Unit Total : 4.6830 f(s)

Pick :

Qty Part # Description Batch

2 D2856-400 6.9" Abrasion Strip *B29285* ✓*EB 07/01/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:37:24 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACESS STEP LH

Job Number: 29302

Part Number: D206628021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS,Y

629166 ✓

7.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-12A Bolt

1102380 ✓

8.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-13A Bolt

1102630 ✓

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-15A Bolt

1102039 ✓

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer

1101938 ✓

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4 Nut (or MS21042-4)

119185 ✓

07/01/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: PD Date: 07/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:37:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 29302

Part Number: D206628021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*PU 7/01/04 (4)*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-021

Location: \_\_\_\_\_

PPP Rev: 12

*EB 07/01/16 (4)*  
*7/01/16 (4)*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/01/16 (4)*  
*07/01/16*

Job Completion



*U 07-01-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

628-021

Dart Aerospace Ltd.

Date: Monday, 11/6/2006 1:37:32 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, LH  
 Job Number : 29302A  
 Estimate Number : 11702  
 P.O. Number : N/A Part Number : D2724041  
 This Issue : 11/6/2006 S.O. No. : N/A Drawing Number : D2724 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C  
 Previous Run : 29119A Material : N/A  
 Due Date : 11/27/2006 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	328215

Check Material for any Dents or Defects

PE 06-11-23

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724  
 Deburr and bevel ends for welding

PE 06-11-23

PE 06-11-23

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	327281

PE 06-11-23

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	329354

PE 06-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 11/6/2006 1:37:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 29302A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

329355=2  
329069=6

PE. 06.11.23  
PE. 06.11.23

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884

followed by Jig

DT (One End Only)

A/R AL ROD Batch:

M100237  
M19612

PE. 06.12.1  
PE. 06.12.1

Grind end cap welds flush

PE. 06.12.5

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/12/05 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/05 (4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.R. 06/12/07 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE. 07.01.10

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

PE. 07.01.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/16

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/6/2006 1:37:32 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 29302A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD

Batch:

~~0329340~~ ~~1100239~~ <sup>M19612</sup>

*FE 07.01.10*

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*07/01/11 (4)*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

*M.R /am*

*07/01/11*

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*FL/ml*

*07/01/15*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ml 07 01 15*

*(4)*

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

*m103004*

*ml 07 01 15*

*(4)*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL*

*07 01 15*

*(4)*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*1/2*

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/01/16*

Job Completion



*u 07 01 16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

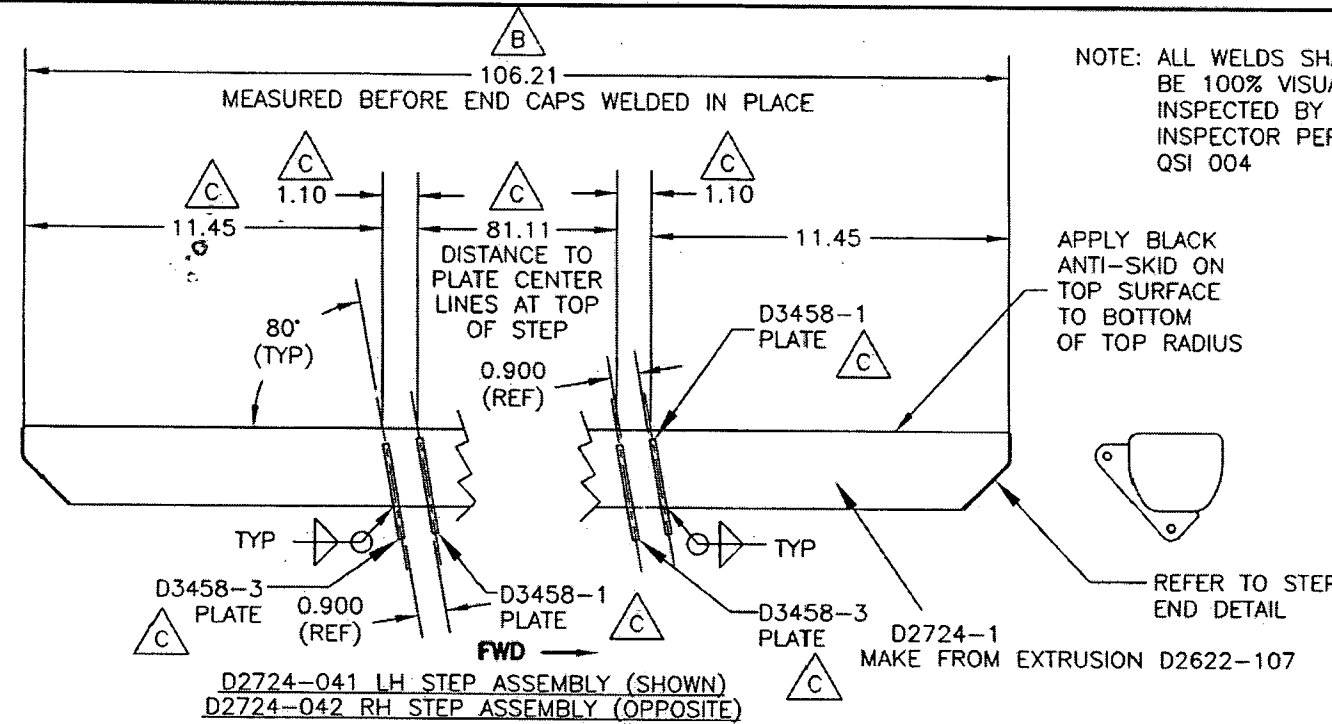
NOTE: Date & initial all entries

**DART**

RELEASED  
05.11.14

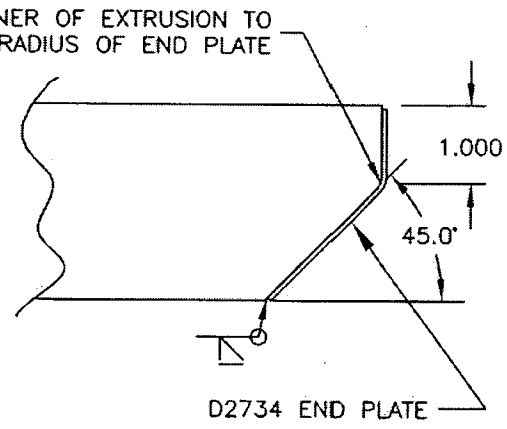
DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	206L/407 STEP ASSEMBLY	REV. C
	A	97.12.04	NEW ISSUE	
	B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
	C	05.09.19	RE-DESIGN, ADD D3458-1/-3	
			SCALE	
			NTS	

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



**TYPICAL STEP END DETAIL**  
NOT TO SCALE

**D2724-041/-042 STEP ASSEMBLY**

- MAKE FROM EXTRUSION D2622
- WELD PER DART QSI 004
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- ALL DIMENSIONS ARE IN INCHES
- ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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